

*Splil*

Work Order ID 97598-2

\*97598\*

Page 1

February-21-13 1:48:09 PM

Item ID: D4008-041

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Fuel Filler Splash Guard Assembly

Start Date: 2/20/13

Start Qty: 4.00

\*4\*

Cust Item ID:

Required Date: 2/28/13

Req'd Qty: 4.00

\*4\*

Customer:

Reference:

Run Start

\*NR1\*

Approvals: Process Plan: *MLS*

Date: *13-02-25* Tooling:

Date:

Stop

\*NR2\*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4008

C

100

0.00

\*100\*

Waterjet

FLOW CNC Waterjet

*6061.032*

Memo

1-Cut as per Dwg (D4008-1)

Dwg Rev: *C*

Prog Rev: *C*

2-Deburr if necessary

0.00

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Quality Control

Memo

0.00

*4*

*0*

*Jim 3-21*

*4*

*0*

*Jim 3-21*

**Work Order ID 97598**

February-21-13 1:48:09 PM

**\*97598\***

Page 2

Item ID: D4008-041

Accept

**\*N9000040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Fuel Filler Splash Guard Assembly

Start Date: 2/20/13 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 2/28/13 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC8- Inspect parts - second check

0.00

**\*120\***

QC

Memo

0.00

Quality Control

130

Bend as per dwg

0.00

**\*130\***

Brake NC

Memo

0.00

Brake NC

Bend D4004-1 as per Dwg

140

QC5- Inspect part completeness to step on W/O

0.00

**\*140\***

QC

Memo

0.00

Quality Control



# Work Order ID 97598

February-21-13 1:48:09 PM

**\*97598\***

Page 3

Item ID: D4008-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Fuel Filler Splash Guard Assembly  
 Start Date: 2/20/13 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 2/28/13 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start **\*NR1\***  
 QC: Date: SPC (Y/N): Date: Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150	Chemical Conversion Coat per QSI005 4.1	0.00							
<b>*150*</b>									
HandFinish	Memo	0.00							
Hand Finishing									

*Handwritten: 4 NG 13.3.21*  
*Handwritten: 2 NG 13.4.10*

155	QC7-Inspect Chemical Conversion Coat	0.00							
<b>*155*</b>									
QC	Memo	0.00							
Quality Control									

*Handwritten: 4X M/L 13/03/22*

160	Gloss Grey (4.3,5.15) per QSI 005 4.3	0.00							
<b>*160*</b>									
Powdercoat	Memo	0.00							
Powder Coating									

*Handwritten: 4X M/L 13/03/22*

\*\*\*REMOVE PIN PRIOR TO POWDERCOATING\*\*\*  
 Start Time: 9:00  
 Oven Temperature: 3200 F  
 Finish Time: 9:30

*Handwritten: M118533 2X M/L 13/04/11*

*Handwritten: Start Time: 10:45  
 Temp: 3200 F  
 Finish Time: 11:15*

*Handwritten: M118533*

# Work Order ID 97598

February-21-13 1:48:09 PM

**\*97598\***

Page 4

Item ID: D4008-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Fuel Filler Splash Guard Assembly  
 Start Date: 2/20/13 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 2/28/13 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start **\*NR1\***  
 QC: Date: SPC (Y/N): Date: Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC3- Inspect Part Finish	0.00							
<b>*170*</b>									
QC	Memo	0.00							
Quality Control									
180		0.00							
<b>*180*</b>									
Small Fab	Memo	0.00							
Small Fab	Assemble as per dwg								
190	QC5- Inspect part completeness to step on W/O	0.00							
<b>*190*</b>									
QC	Memo	0.00							
Quality Control									

4 φ 13-3-22  
 2 φ 13/02/11

2x  
 PTO

13411

2



NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Just Date: 13/04/19QA Closed: cll Date: 13/4/18

Work Order: <u>97598-2</u>	<b>DISPOSITION</b> Rework <input checked="" type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>			
Part No. <u>D4008-041</u>		Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>
NCR No. <u>13.2520</u>		Machining <input type="checkbox"/>	Small Fab <input checked="" type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>
		Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>
		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

130325180

2

while assembling crazy glue  
bottle exploded on employee  
and 2 parts.

(130325)

- disassemble

- strip powder coat

- realodine

- re-powder coat (mask)

13/03/25

13-04-09

M-F

13/04/11

DAS 27

13415

(DAS 16)

Q72042

13/04/10

## FAULT CATEGORY

## Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

## General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio

- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabelled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions

- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge

- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☒ Other

handling / preservation

# Work Order ID 97598

February-21-13 1:48:09 PM

**\*97598\***

Page 5

Item ID:	D4008-041	Accept	<b>*N9000040100*</b>	Setup	Start	<b>*NS1*</b>
Revision ID:					Stop	<b>*NS2*</b>
Item Name:	Fuel Filler Splash Guard Assembly					
Start Date:	2/20/13	Start Qty: 4.00	<b>*4*</b>	Cust Item ID:		
Required Date:	2/28/13	Req'd Qty: 4.00	<b>*4*</b>	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	<b>*NR1*</b>
	QC:	Date:	SPC (Y/N):	Date:		Stop	<b>*NR2*</b>

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Identify as per dwg & Stock Location	0.00							
<b>*200*</b>									
Packaging	Memo	0.00							
Packaging									
210	QC21- Final Inspection - Work Order Release	0.00							
<b>*210*</b>									
QC	Memo	0.00							
Quality Control									

2K

13-4-12

13/4/15

13-04-12



# Picklist Print

February-21-13 1:48:08 PM

Page 1

Work Order ID: 97598

Parent Item: D4008-041

Parent Item Name: Fuel Filler Splash Guard Assembly

Start Date: 2/20/13

Required Date: 2/28/13

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP rev A 10.01.27 New issue Prelim EC verified by:DD IPP Rev:B 10.05.03 as per ECN10-562 DD verified by:EC IPP REV:C 12.03.07 AS PER DWG REV.C DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032 6061-T6 Sheet 0.032"		Purchased	No			100	sf	1,160.0700	0.2735	1.1515789 1.25			JWB3-21
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT021		1160.07							
				121099		171.94							
				122256		46.78							
				122737		44.8							
				123097		71.9							
				123135		37.7							
				123137		66.05							
				123293		58.5							
				123483		263.4							
				123701		63				0.2735			
				124629		336							
D3941 Rubber Cushion		Manufactured	No			180	f	36.5174	0.21	0.8842105			LB 3/03/22
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST414		36.517382				0.8842105			
				48512		36.517382							
D4008-5 Fuel Filler Splash Guard Hinge Half		Manufactured	No				Each	5.0000		4			LB 3/03/22
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA003		5				4			
				85782		5							
D4008-9 Spring		Manufactured	No			180	Each	3.0000	1	4			LB 3/03/22
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		3				3			
				80632		3							

397485  
(10)

# Picklist Print

February-21-13 1:48:09 PM

Page 2

Work Order ID: 97598

Parent Item: D4008-041

Parent Item Name: Fuel Filler Splash Guard Assembly

Start Date: 2/20/13

Required Date: 2/28/13

Start Qty: 4.00

Required Qty: 4.00

D4008-7  
Washer

Manufactured No

180 Each 16.0000 2

8 *EP 13/03/22*

Location

Loc Qty

Loc Code

GA 16  
80629 1  
85659 15

MS20470AD3-3  
Rivet, Universal Head

Purchased No

180 Each 6,277.0000 5

20 *EP 13/03/22*

Location

Loc Qty

Loc Code

ST335 6277  
1065 1307  
16941 4970

MS21042L08  
Nut

Purchased No

180 Each 4,078.0000 2

8 *EP 13/03/22*

Location

Loc Qty

Loc Code

ST315 4078  
122141 3  
122452 9  
122814 500  
123900 3566

MS35206-S245  
Screw

Purchased No

180 Each 100.0000 2

8 *EP 13/03/22*

Location

Loc Qty

Loc Code

ST289 100  
122459 100



# Picklist Print

February-21-13 1:48:09 PM

Page 3

Work Order ID: 97598  
Parent Item: D4008-041  
Parent Item Name: Fuel Filler Splash Guard Assembly  
NAS1149DN832J  
WASHER

Purchased No

180 Each 2,359.0000 6

Start Date: 2/20/13

Required Date: 2/28/13

Start Qty: 4.00

Required Qty: 4.00

24

*Handwritten signature and date: 2/13/03/22*

## Location

## Loc Qty

## Loc Code

ST293

1959

123248

22

123348

383

123352

200

123603

400

123900

554

124555

400

ST509

400

124093

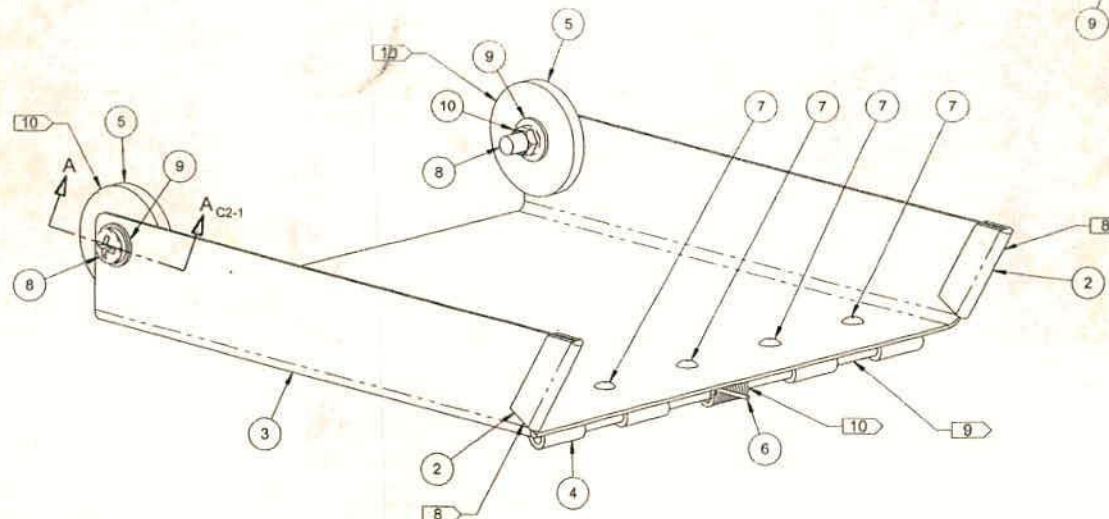
400

*Handwritten number: 24*





ITEM NO.	QTY -041	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4008-041	AUX TANK FILLER SPLASH GUARD ASSEMBLY	JCA-M47-2-26
2	2	D3941-1	RUBBER CUSHION	
3	1	D4008-1	FUEL FILLER SPLASH GUARD CHANNEL	
4	1	D4008-5	HINGE HALF	
5	2	D4008-7	WASHER	
6	1	D4008-9	SPRING	
7	5	MS20470AD3-3	RIVET	
8	2	MS35206S245	SCREW	
9	6	NAS1149DN832J	WASHER	
10	2	MS21042L08	NUT	



# SECTION A-A

SCALE: 2X B6-1  
TYP

**D4008-041 AUX TANK FILLER SPLASH GUARD ASSEMBLY**

## NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "ANSI 61 GREY" (4.3.5.15) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
- 7) WEIGHT: 0.15 lbs
- 8) ATTACH D3941-1 RUBBER CUSHION USING SILICONE ADHESIVE, TRIM TO FIT, AFTER POWDER COAT
- 9) MASK HINGE PIN AREA BEFORE POWDER COAT
- 10) INSTALL D4008-7 WASHER AND D4008-9 SPRING AFTER POWDER COAT

REV.	DESCRIPTION	BY	DATE
C	CHANGE POWDER COAT FROM "GREY SANDTEX" TO "ANSI 61 GREY", CORRECT MATERIAL ERROR, ZN A7-5 ADD D4597-1 TO D4008-043, ZN C4-2.	DC	12.01.17
B	ADD ALTERNATE RIVETS FOR -043, ZN D7-2	HS	10.11.03
A	NEW ISSUE	HS	10.02.05
DESIGN	DATE	12.01.17	
DRAWN	DATE		
CHECKED	DATE		
MFG APPR.	DATE		
APPROVED	DATE		
DE APPR.	DATE		
DATE	12.01.17		

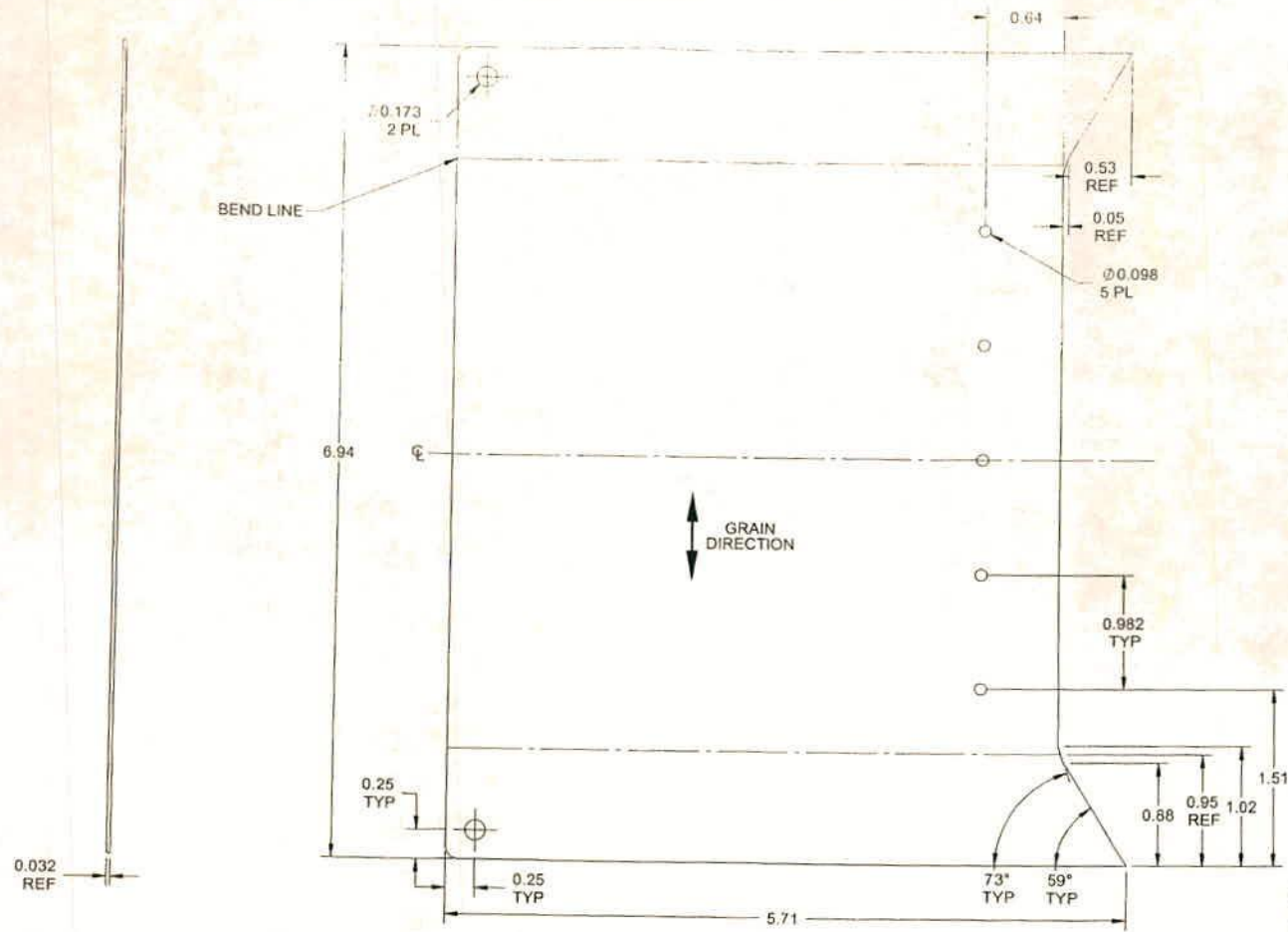
**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4008** REV. C  
SHEET 1 OF 10

TITLE **SPLASH GUARD** SCALE NTS

COPYRIGHT © 2010 BY DART AEROSPACE LTD  
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR DISSEMINATION TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD

97598 MJS  
13-02-25



D4008-1F FLAT PATTERN

RELEASED  
2012-03-02

NOTES:

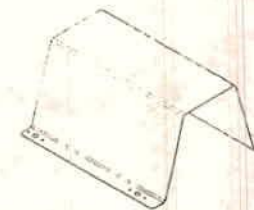
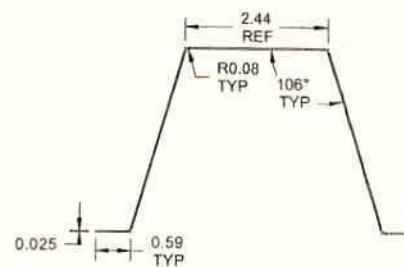
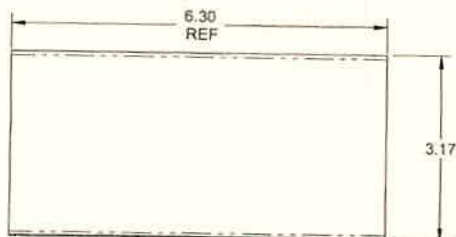
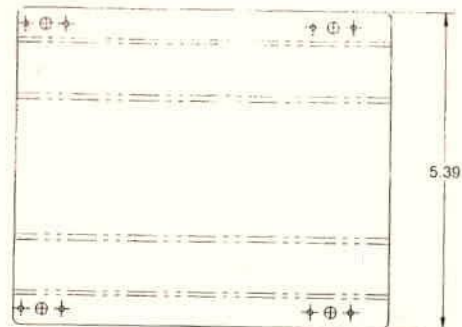
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.032 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC M6061T6S.032
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.11 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4008	SHEET 4 OF 10
APPROVED		TITLE	SCALE
DE APPR.		SPLASH GUARD	NTS
DATE	12.01.17	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



DART AEROSPACE  
PART NUMBER  
D4008-3

JOHN CAMERON AVIATION  
PART NUMBER  
REF JCA-M47-2-29



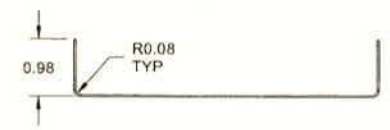
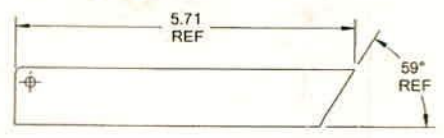
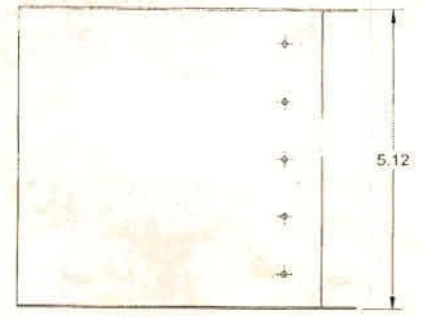
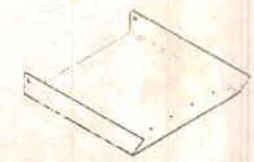
**D4008-3 FUEL PUMP SPLASH GUARD COVER**

**NOTES:**

- 1) MATERIAL: MADE FROM D4008-3F
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.45 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4008	SHEET 5 OF 10
APPROVED		TITLE	SCALE
DE APPR.		SPLASH GUARD	NTS
DATE	12.01.17	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL. AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

97510



**D4008-1 FUEL FILLER SPLASH GUARD CHANNEL**

RELEASED  
LA 2012-03-02  
JWP

- NOTES:
- 1) MATERIAL: MADE FROM D4008-1F
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART OSI 005 4.1
  - 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.11 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BC	DRAWING NO.	REV. C
MFG. APPR.	BC	D4008	SHEET 3 OF 10
APPROVED	JWP	TITLE	SCALE
DE APPR.		SPLASH GUARD	NTS
DATE	12.01.17	COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS UNCLASSIFIED AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	